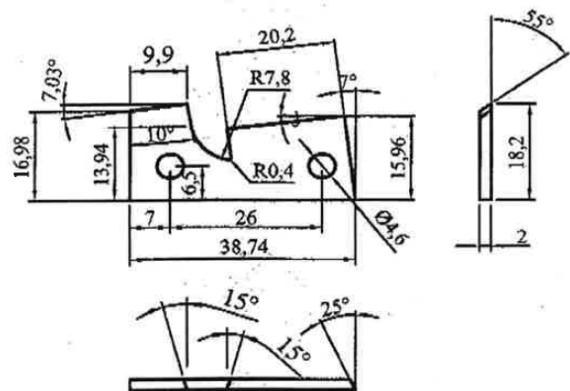


## Removeable Insert 38 x 18.2

A09-010

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels and automatic calculation of the wheelorientation to achieve the required radial and axial clearance. Probing is measuring the reference of the insert - hole, side, ceration or other geometries - if necessary.



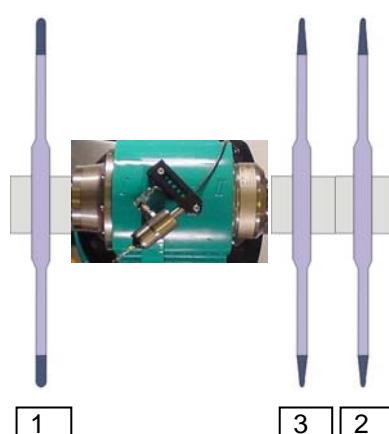
### 1. Cycletime for Production

Workpiece: 40 x 25, t = 2 mm Material CARBIDE				
Operations	Probe	Prf Rough	Prf Pgrd	Prf fin
Feed [mm/Min]	2000	100	80	100
Power [kW]		2	1	1
Cutting feed [m/s]		20	22	22
Used wheels		1	2	3
Grinding time [s]	20	310	52	43
Total cycle time	7 Min 5			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14F1 Ø200 D76R1.5
2	14EE1 Ø200 D76R0.8
3	14EE1 Ø200 D64R0.4



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsable engineer: OP. 3.8.10

[www.schneeberger.ch](http://www.schneeberger.ch)

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